

# Work Order ID 81477

Wednesday, March 14, 2012 3:08:42 PM

**\*81477\***

Page 1

Item ID: D4148-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Crosstube Lug Plate, Fwd

Stop **\*NS2\***

Start Date: 3/14/2012 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 3/30/2012 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4148	D

100

0.00

**\*100\***

Waterjet

FLOW CNC Waterjet

Memo

Cut as per dwg D4148

Prog Rev: B

Dwg Rev: B

Deburr as required

0.00

*W* 12.03.15 (12)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Quality Control

Memo

0.00

*W* 12.03.18 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 81477

**\*81477\***

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Wednesday, March 14, 2012 3:08:42 PM

Item ID: D4148-1      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
 Revision ID:      Stop **\*NS2\***  
 Item Name: Crosstube Lug Plate, Fwd  
 Start Date: 3/14/2012      Start Qty: 12.00      **\*12\***      Cust Item ID:  
 Required Date: 3/30/2012      Req'd Qty: 12.00      **\*12\***      Customer:  
 Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start **\*NR1\***  
                  QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
<b>*120*</b>									
QC	Memo	0.00					12/03/21		322
Quality Control									
150	Identify as per dwg & Stock Location: <b>ST/32</b>	0.00							
<b>*150*</b>									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

**(12x) SP 12-03-23**

**12/3/26**

**12-03-23**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, March 14, 2012 3:08:42 PM

Page 1

Work Order ID: 81477

Parent Item: D4148-1

Parent Item Name: Crosstube Lug Plate, Fwd

Start Date: 3/14/2012

Required Date: 3/30/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC  
IPP Rev:B 10.10.29 as per revC DD verf:EC  
DWG REV.D DD VERF:EC

IPP REV:C 11.03.02 AS PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 304/316 0.125 Sheet		Purchased	No			100	sf	31.1000	0.3607	4.5562105		m 12.03.12	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				MAT020		31.1							
				120243		26							
				120604		5.1							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	81477
<b>Description:</b> Fwd Crosstube Lug Plate		<b>Part Number:</b>	D4148-1
<b>Inspection Dwg:</b> D4148	<b>Rev:</b> D	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.134	✓		vern	HB-02
Ø0.191	+0.005/-0.001	0.195	✓		vern	
Ø0.38	+0.006/-0.001	0.38✓	✓		vern	
Ø0.257	+0.006/-0.001	0.260	✓		vern	
Ø0.50	+0.008/-0.001	0.50	✓		vern	
0.94	+/-0.030	0.94	✓		vern	
4.47	+/-0.030	4.473	✓		vern	
0.750	+/-0.010	0.748	✓		vern	
8.47	+/-0.030	8.47	✓		M.T	HB-01
8.096	+/-0.010	8.100	✓		vern	Prod W-T-02
5.43	+/-0.030	5.431	✓		vern	HB-02
5.197	+/-0.010	5.190	✓		vern	
4.733	+/-0.010	4.737	✓		vern	
0.310	+/-0.010	0.309	✓		vern	
0.750	+/-0.010	0.744	✓		vern	
0.375	+/-0.010	0.380	✓		vern	
1.84	+/-0.030	1.85	✓		vern	
0.92	+/-0.030	0.928	✓		vern	
3.000	+/-0.010	3.000	✓		vern	
0.750	+/-0.010	0.748	✓		vern	
0.625	+/-0.010	0.625	✓		vern	
1.982	+/-0.010	1.97	✓		vern	
0.991	+/-0.010	0.991	✓		vern	
0.77	+/-0.030	0.775	✓		vern	
1.54	+/-0.030	1.548	✓		vern	
2.47	+/-0.030	2.50	✓		vern	
0.82	+/-0.030	0.823	✓		vern	
3.57	+/-0.030	3.57	✓		vern	
1.23	+/-0.030	1.23	✓		vern	
0.73	+/-0.030	0.734	✓		vern	
0.125	+/-0.010	0.117	✓		vern	
Ø0.252	+0.003/-0.000	0.254	✓		vern	

<b>Measured by:</b>	<i>WJA</i>	<b>Audited by:</b>	<i>SRR</i>	<b>Preliminary Approval:</b>	
<b>Date:</b>	12/03/18	<b>Date:</b>	12/03/21	<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	
B	10.10.08	Dwg Rev updated	KJ	
C	10.11.05	Dimensions updated per Dwg Rev C	KJ	
D	11.03.08	Dwg Rev updated	KJ	
E	12.02.01	Dimensions updated per Dwg Rev D	KJ	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

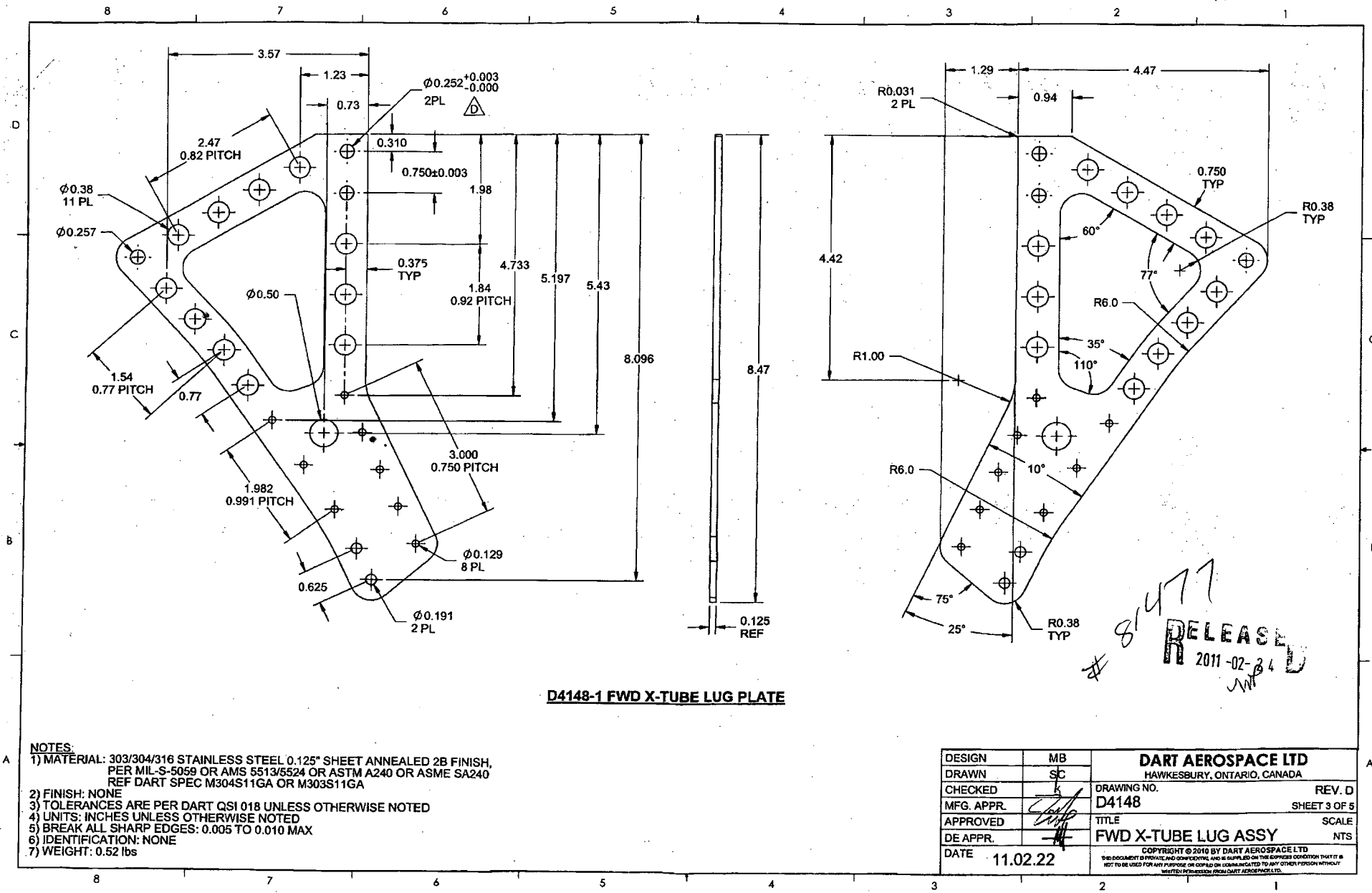
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**NOTE:** Date & initial all entries



127  
07L  
067  
190



**D4148-1 FWD X-TUBE LUG PLATE**

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA OR M303S11GA
  - 2) FINISH: NONE
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.52 lbs

DESIGN	MB	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4148	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
DATE	11.02.22	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPARISON UNLESS SPECIFICALLY AUTHORIZED BY DART AEROSPACE LTD.</small>	

# 81477  
RELEASE  
2011-02-24  
JW

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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